

Work Order ID 68488-2

Thursday, April 14, 2011 10:12:48 AM



Page 1

Item ID: D3319-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 4/14/2011 Start Qty: 8.00



Cast Item ID:

Required Date: 4/21/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: *M*

Date: 4-14-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3319

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319
Deburr if necessary

Dwg Rev: *B*

Prog Rev: *B* .2

1010 OK

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/11

3-4-11

131-4-11

(28)

Work Order ID 68488

Thursday, April 14, 2011 10:12:48 AM



Page 2

Item ID: D3319-3

Revision ID:

Item Name: Wearplate

Start Date: 4/14/2011 Start Qty: 8.00

Required Date: 4/21/2011 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr if necessary

N/A

140



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form using DT8326 & DT8261 as per Dwg D3319Rev: B

8 5/10/11

150



QC

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

5/10/11

Quality Control

78

Work Order ID 68488

Thursday, April 14, 2011 10:12:48 AM

Page 3

Item ID: D3319-3

Revision ID:

Item Name: Wearplate

Start Date: 4/14/2011 Start Qty: 8.00

Required Date: 4/21/2011 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Large Fab

Large Fab

Large Fab

Memo

0.00

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev
Qty Part Number Description Batch A/R
N/A 7560 Hardcoat Rod M117139

11-5-10 (TS)

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/11/13

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/13

(TS)

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Item Name: Wearplate

Stop



Start Date: 4/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

Grey Sandtex(Ref:4.3 5 6) per QSI005 4 3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

OVEN TEMPERATURE

FINISH TIME

12:30

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-3, Q/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: 497

(5x) m-f 11/05/13

11/5/13

11/5/17 SD SD

Work Order ID 68488

Thursday, April 14, 2011 10:12:48 AM



Page 5

Item ID: D3319-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 4/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18

MF
11-05-17

Picklist Print

Thursday, April 14, 2011 10:12:55 AM

Page 1

Work Order ID: 68488

Parent Item: D3319-3

Parent Item Name: Wearplate



Start Date: 4/14/2011

Required Date: 4/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A 05.05.12 New issue: KJ/JLM
IPP Rev:B Now on Waterjet 06-10-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	62.5000	3.2524	27.38863			



1010/1025 SHEET, 048



B 11-4-18

Location

Loc Qty

Loc Code

MAT019

62.5

116268

62.5

116268

DART AEROSPACE LTD		Work Order:	68488
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: B	Page 1 of 1	

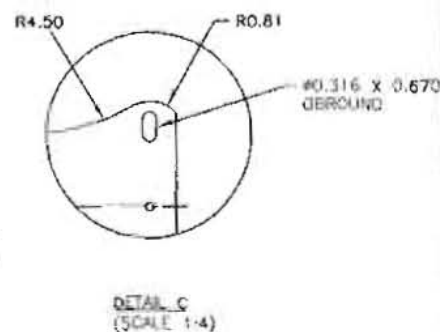
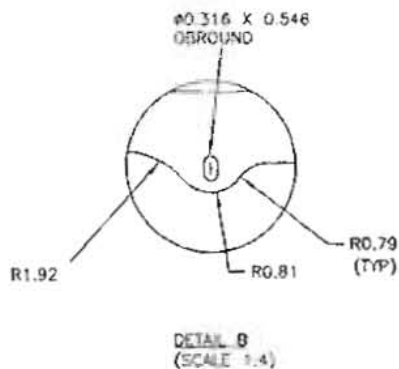
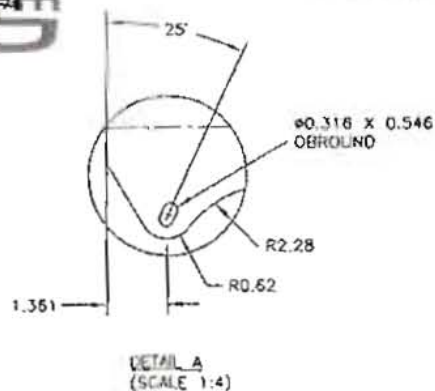
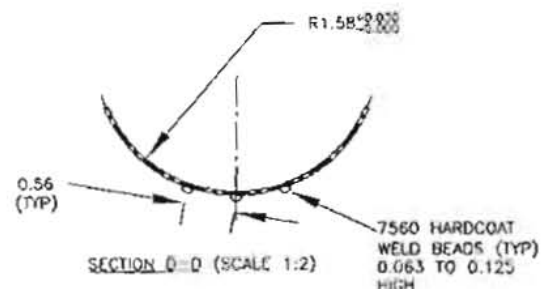
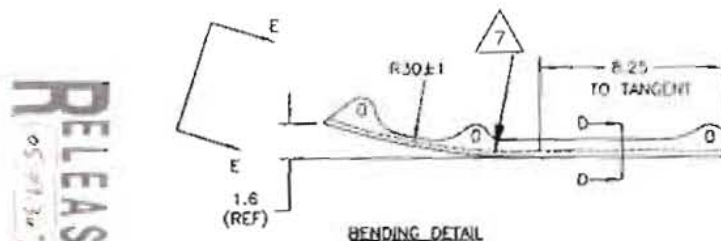
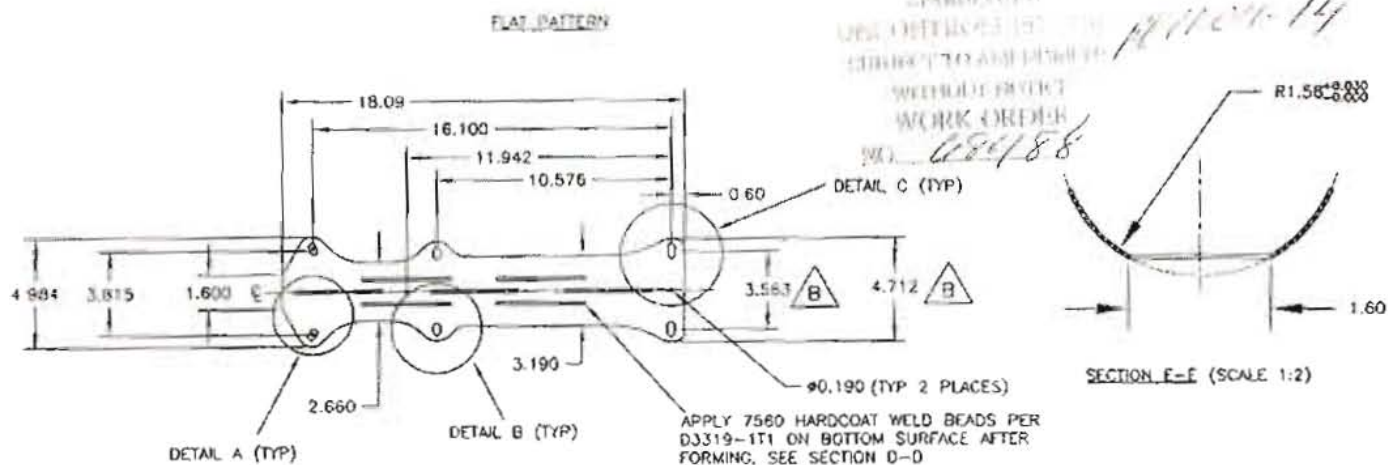
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	✓		T B01	
74.420	+/-0.010	74.42	✓		T	
62.770	+/-0.010	62.770	✓		T	
52.890	+/-0.010	52.890	✓		T	
30.790	+/-0.010	30.790	✓		T	
8.690	+/-0.010	8.690	✓		T	
0.60	+/-0.030	.594	✓		V B02	
2.690	+/-0.010	2.697	✓		V	
2.940	+/-0.010	2.949	✓		V	
3.527	+/-0.010	3.525	✓		V	
4.518	+/-0.010	4.515	✓		V	
Ø0.190	+0.005/-0.001	.192	✓		V	
2.940	+/-0.010	2.950	✓		V	
2.940	+/-0.010	2.947	✓		V	
2.690	+/-0.010	2.697	✓		V	
5.063	+/-0.010	5.060	✓		V	
6.163	+/-0.010	6.162	✓		V	
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	316 x .607	✓		V	
0.048	+/-0.010	.045	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-4-8	Date: 11/04/19	Date:	N/A
Rev	Date	Change	Revised by
A	07.07.18	New Issue	KJ/JLM
			Approved
			RB

DART



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART OSI 005 4.3
- 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART OSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:

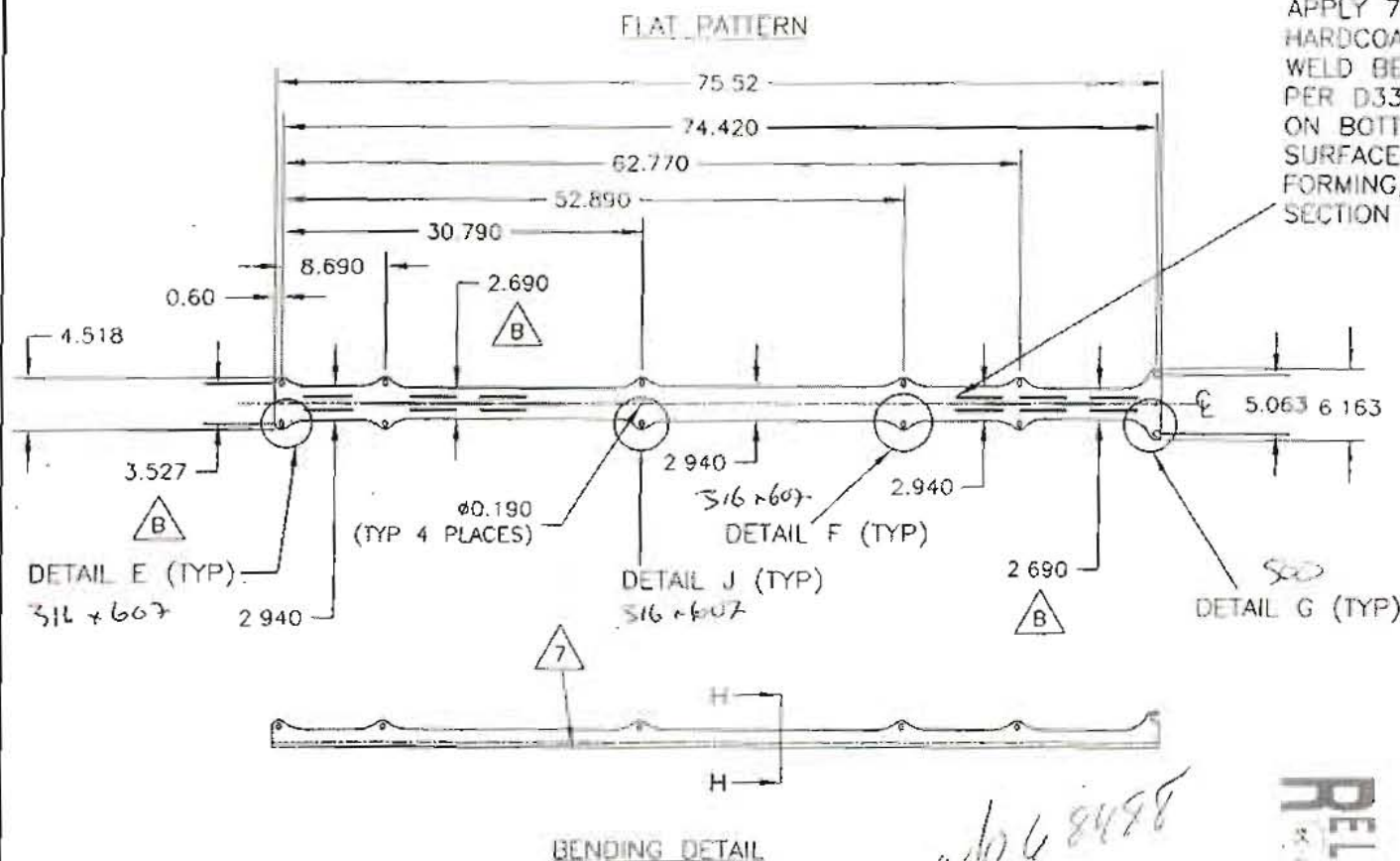
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
#1	#1	HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#1	#1	D3319
DATE	TITLE	SHEET
05.06.06	WEARPLATE	1 OF 5
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE 1:8

RELEASED
05-07-2000

DART

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

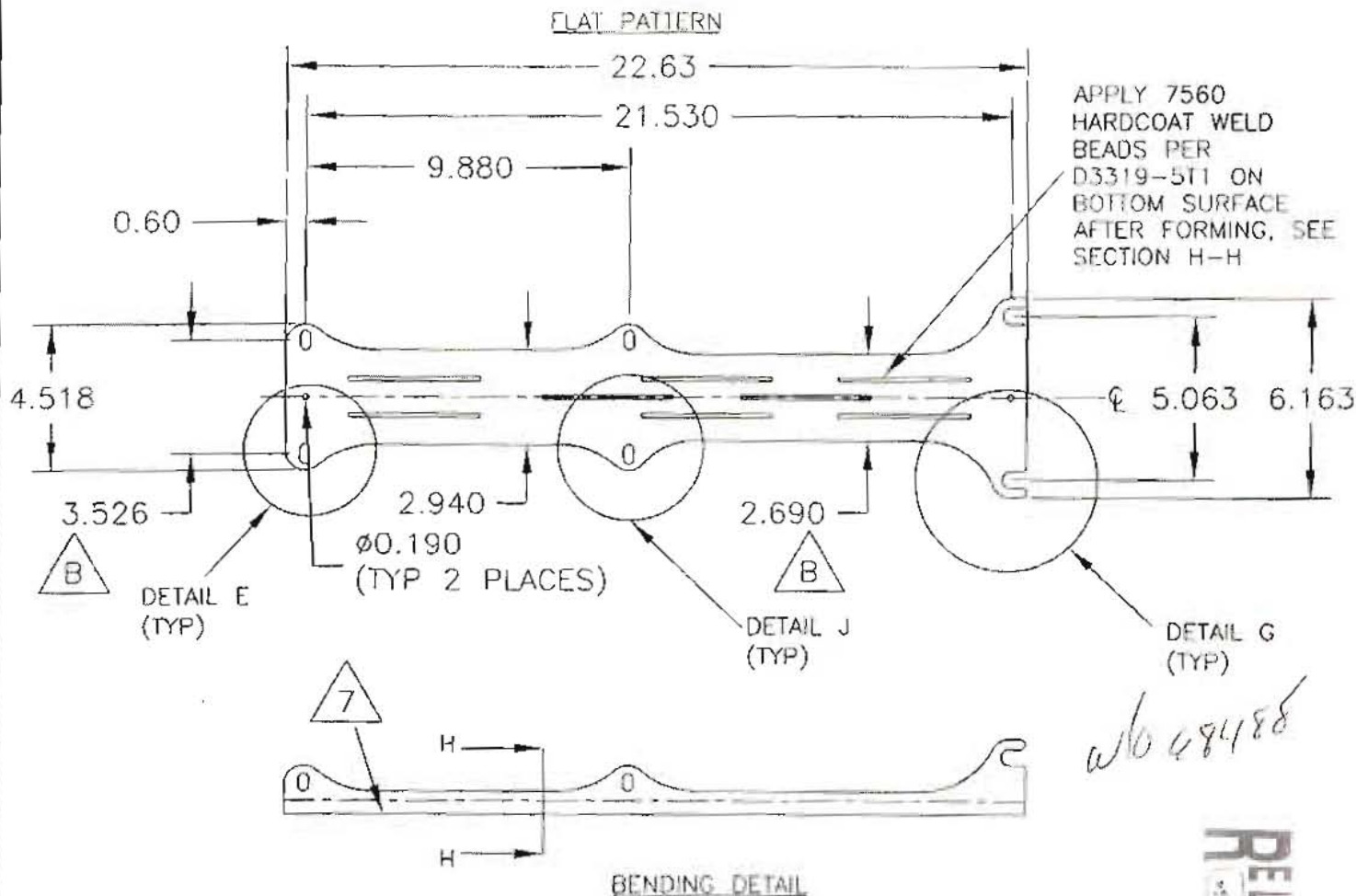


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 2 OF 5
	TITLE	SCALE
	WEARPLATE	1:1.5

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

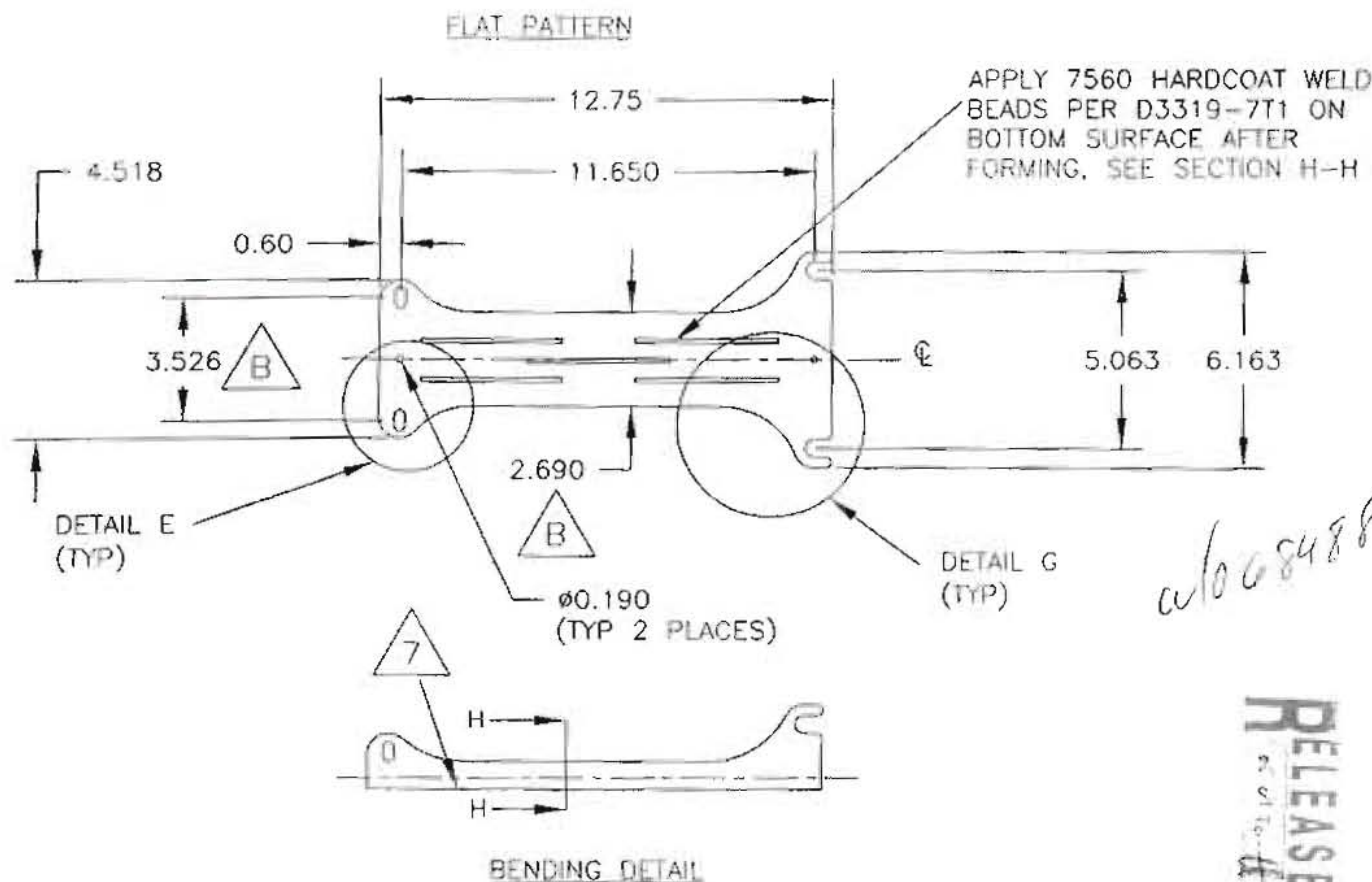


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CHECKED	#	APPROVED	#	HAMMERSBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REVISION
			WEARPLATE	SHEET 3 OF 5
				SCALE 1:5

D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005.4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

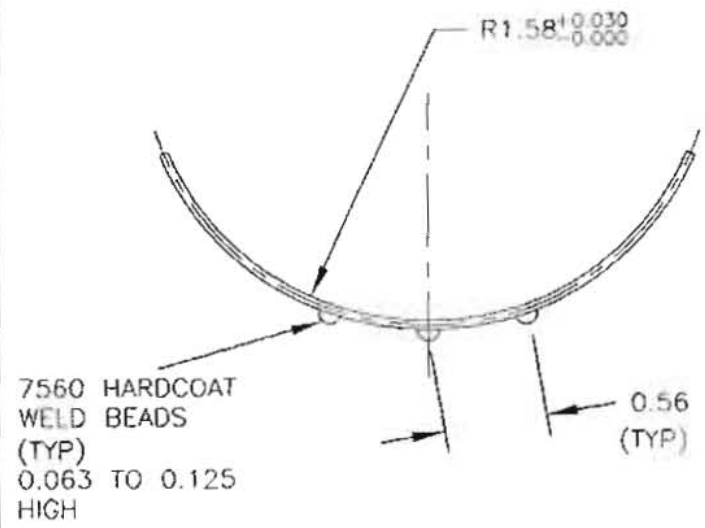
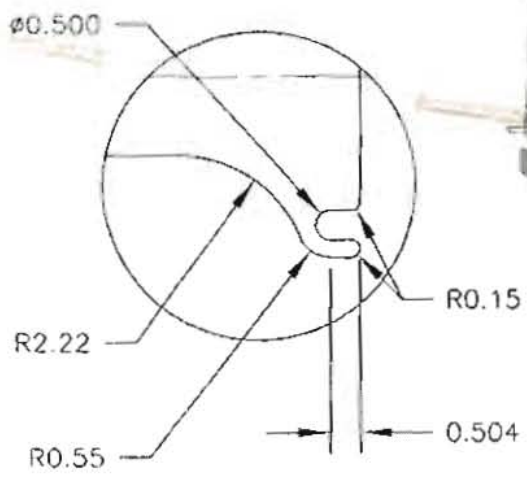
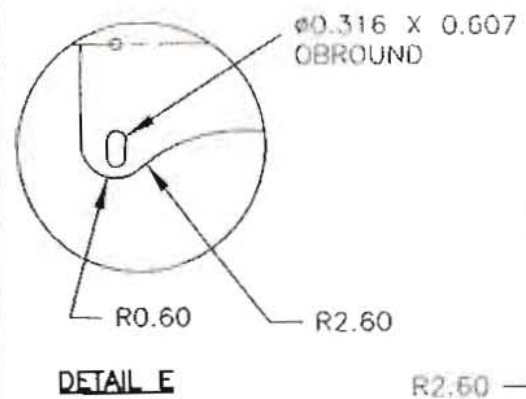
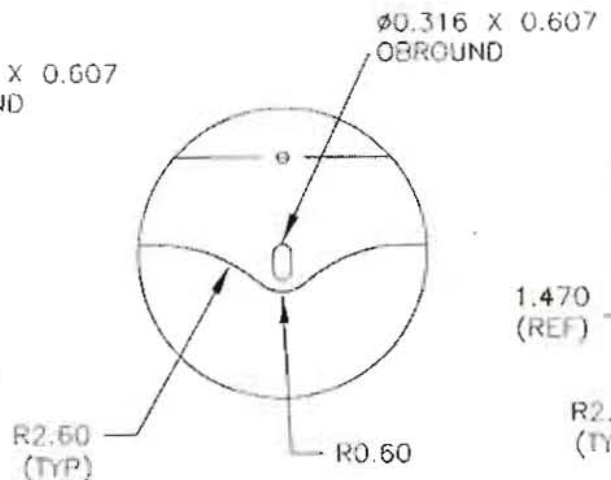
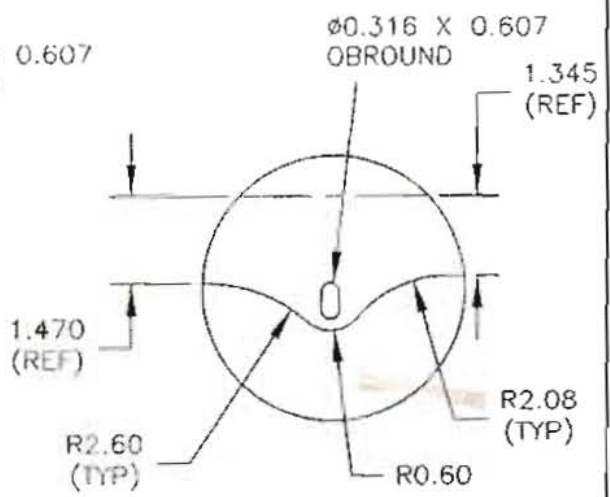
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CHECKED	APPROVED	DRAWING NO.
P4	P4	D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1-5
		SHEET 4 OF 5
		REV 8

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D3319	SHEET 5 OF 5
05.06.06		TITLE	SCALE
		WEARPLATE	1:3

RELEASED
15 of 30

W/068488



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